

Work Order ID 130696

Monday, March 23, 2015 9:16:06 AM

130696

Page 1

Item ID: D6104-007 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Round Billet, 17-4
 Start Date: 3/23/2015 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 3/23/2015 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: AA Date: 15-03-23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D6104	Rev B

100 PURCHASING 0.00
100
 Purchasing
 Purchasing
 Memo
 Issue P/O: 27890
 a) Description: S.S round billet
 b) Ø4.50" x 5.10" long
 c) Tolerance on all dimensions are +0.030"/-0.000"
 d) Material: 17-4PH Stainless steel (Ams 5643 or Aisi 630)
 e) One blank makes 2 parts
 f) Material certification required

CZ 15/03/25 10

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging
 Packaging
 Memo
 Ensure material certification is attached

10X 8015-03-31

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

Monday, March 23, 2015 9:16:06 AM

Item ID: D6104-007 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Round Billet, 17-4
 Start Date: 3/23/2015 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 3/23/2015 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC18 In-Coming Inspection Material	0.00							DAS 14 9-89
120						10	10		15/04/08
QC	Memo	0.00							
Quality Control	Ensure Material certification comply to Dwg D6104								
130	Identify as per dwg & Stock Location: <i>MAI 43</i>	0.00							DAS 14 9-89
130						10	10		15/04/08
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140						MLJ	15-04-08		
QC	Memo	0.00							
Quality Control									

DSH-8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Monday, March 23, 2015 9:16:11 AM

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Work Order ID: 130696

130696

Parent Item: D6104-007

D6104-007

Parent Item Name: Round Billet, 17-4

Start Date: 3/23/2015

Required Date: 3/23/2015

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A: 01.05.08New Issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-007P		Purchased	No			110	Each	0.0000	1	10			
D6104-007P									**	10 x 8015-03-31			
17-4 SS Roundbar 4.50"Od													

DQA: _____ Date: _____



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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

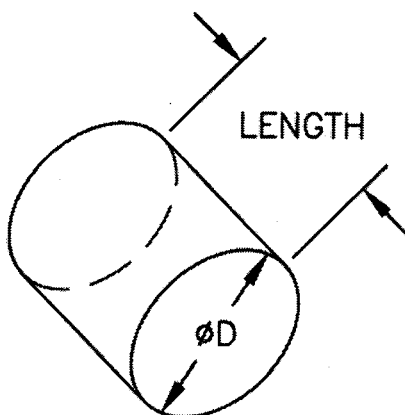
Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DESIGN <i>RF</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6104	Rev. B SHEET 1 OF 1
DATE 02.11.25		TITLE ROUND BILLET, 17-4	SCALE NTS
A	01.04.10	NEW ISSUE	
B	02.11.25	CLARIFY ALLOY SPEC ADDED D6104-009/-011 REDUCE LENGTH OF BILLETS	

RELEASED
02.11.29 *[Signature]*

SPECIFICATION CONTROL DRAWING



130696.MLS
1503-23

MATERIAL: 17-4 PH SS (AMS 5643 OR AISI 630) MIN UTS = 170 KSI (38 HRC)

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES

Part No.	Alloy	D (Diameter)	Length
D6104-001	17-4 PH STAINLESS STEEL	Ø3.00	3.80
D6104-003	17-4 PH STAINLESS STEEL	Ø3.25	3.80
D6104-005	17-4 PH STAINLESS STEEL	Ø4.00	5.10
D6104-007	17-4 PH STAINLESS STEEL	Ø4.50	5.10
D6104-009	17-4 PH STAINLESS STEEL	Ø5.25	4.10
D6104-011	17-4 PH STAINLESS STEEL	Ø6.50	4.10

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DART
AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27890**

Purchase Order Date 3/25/2015

PO Print Date 3/25/2015

Page Number 2 of 3

Order From :
METAUX CASTLE
A.M. CASTLE & CO. (CANADA) INC. - C/O 910720
P.O. BOX 4090 STN A
TORONTO, ON M5W OE9
CA

VC-MET001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 514 694 9575

Ship To Contact
Ship To Phone
Ship Via: VENDOR'S TRUCK
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 10
Currency CAD
FOB FCA - (Free Carrier)

3	D6104-007P	17-4 SS Roundbar 4.50"Od	3/31/2015 Yes 3/31/2015	10.00 Each	\$113.00	\$1,130.00
---	------------	--------------------------	-------------------------------	---------------	----------	------------

AS PER DWG D6104 REV. B
B130696

MATERIAL: 17-4 PH AS PER AMS 4643 OR-AISI 630
SIZE: 4.50" X 5.10" LONG

SP15-03-31

Line Total: \$1,130.00

4	D6104-011P	17-4 SS Roundbar 6.50"Od	4/7/2015 Yes 4/7/2015	28.00 Each	\$174.00	\$4,872.00
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AS PER DWG D6104 REV. B
B130691

MATERIAL: 17-4 PH SIZE: 6.50" X 4.100" LONG

Line Total: \$4,872.00

Note:

3/25/2015

**Castle Metals®**

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 1 of 1

Shipment No:2554264

Ship From: A. M. Castle & Co. MONTREAL - CASTLE METALS 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped	F.O.B.	Freight Terms		Carrier		BOL No	
30-MAR-2015	ORIGIN	Prepaid		MANITOULIN		2554264-2	

Shipment Details	Final Destination Branch - MON
-------------------------	---------------------------------------

Order No 3796008	Line No 2	Item No 14998.MO	Description 4.5000.RD.17CR-4NI.STAINLESS.RT.SOL TR.COND A.132.0000-156.0000 CUT TO 5.1 IN (+ .1250/- .0000 IN) - BAND SAW CUTTING SPECIFICATIONS: AMS 5643				
Purchase Order No 27890		Part Number YOUR ITEM NUMBER: D6104-007	Ordered Qty 10.00 PCS			Invoice Qty 10.00 PCS	
Details		ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #'S END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS SP 15-03-31					
Delivery No. 120004417	Mill	Heat Number 	Mech Id	PCS 10	Width (IN)	Length (IN)	Shipped Qty(LBS) 236.4263

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless written to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material put by the customer cannot be returned for credit.

Reviewed by Authorized Castle Metals Representative:

30 MAR 2015

Name:

These commodities, technology or software were exported from the United States in accordance with the Export Administration Regulations. Diversion contrary to US law prohibited.
Date Printed: 30-MAR-2015 11:20:01 AM

**VALBRUNA**SLATER STAINLESS, INC.
7400 TAYLOR STREET WEST - PO BOX 530
FORT WAYNE IN 46802 USA
PHONE 260.434.2800 - FAX 260.434.2801**Product Certification Report**Report Number: **5018650**

Certified on Jun 24, 2014 Page 1 of 2

Order I.D. 1401499 004	Order Date 6/02/14	Commodity Code			
Dim 1 4.5000	Dim 2 .0000	Dim 3 .0000	Heat I.D. 262511	Customer I.D. 002476	Customer Purchase Order 405004790
Product Shape Rounds		Product Surface HR & Rough Turned			Customer Grade 17-4
Length (Inches) 132.000 Min. 156.000 Max.			Bill of Lading # 422159	Weight	

Ship ToVALBRUNA CANADA LTD.
8724 HOLGATE CRESCENT
MILTON, ONTARIO L9T5Z1**Sold To**VALBRUNA CANADA LTD.
8724 HOLGATE CRESCENT
MILTON, ONTARIO L9T5Z1**DAS
14
9-89****15/04/08****Lifts: 0028****AISI 630****UNS S17400****AMS 2303F****Condition A****ASTMA 564-13****AMS 5643T (except finish)****3174-02 REV 37****ASMESA 564 13****CHEMICAL ANALYSIS**

C	Mn	P	S	Si	Cr	Ni	Mo	Cu	N	Cb	Ta	Cb+Ta
.041	.68	.022	.020	.37	15.88	4.37	.22	3.22	.04	.29	.000	.286

BRINELL HARDNESS ASTM E10-12**HBW****344****TENSILE PROPERTIES ASTM E8-13a****CAPABILITY**

Cap HB	TS (PSI)	.2%YS (PSI)	%EL(4d)	%RA	AGE(F)
416	195600	173000	16.7	56.2	900

MAGNETIC PARTICLE TEST AMS2303**FREQ SEV****AVG .00 .00****MACRO ASTM E340-00/E381-01****MACRO****OK****OK****OK****GRAIN SIZE ASTM E112-12**

GRAIN SIZE	Etchant	Magnification X
6	Marbles	100

PERCENT FERRITE (AMS 2315)**% FERRITE Etchant Magnification X****AVG .3 Marbles 100****No welding or weld repair done.****Material when shipped is free from contamination by mercury, radium, alpha source, and low melting elements.****Reduction Ratio Exceeds 4:1****Electric Furnace melted; AOD refined.****Chemical testing to one or more of the listed ASTM methods:****E415-14, E572-13, E1019-11, E1085-09, E1086-14.**

Results relate only to the items tested. Certification shall not be reproduced except in full, without written approval of Valbruna Stainless Inc. The recording of false, fictitious, or fraudulent statements on this document may be punished as a felony under federal statutes. Including Federal law Title 18, Chapter 47. Consult material safety data sheet (MSDS) for hazard info. I hereby certify that the reported figures are correct as contained in the records of the corporation.

Manager Laboratory Services

email: DHackett@valbruna.us

Dennis Hackett

**VALBRUNA**

SLATER STAINLESS, INC.

2400 TAYLOR STREET WEST - PO BOX 530
FORT WAYNE IN 46802 USA
PHONE 260.434.2800 - FAX 260.434.2801**Product Certification Report**Report Number: **5018650**

Certified on Jun 24, 2014 Page 2 of 2

Order I.D. 1401499 004		Order Date 6/02/14		Commodity Code	
Dim 1 4.5000	Dim 2 .0000	Dim 3 .0000	Heat ID 262511	Customer I.D. 002476	Customer Purchase Order 405004790
Product Shape Rounds			Product Surface HR & Rough Turned		Customer Grade 17-4
Length (Inches) 132.000 Min. 156.000 Max.			Bill of Lading # 422159	Weight	

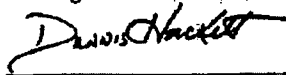
**Ship
To**VALBRUNA CANADA LTD.
8724 HOLGATE CRESCENT
MILTON, ONTARIO L9T5Z1**Sold
To**VALBRUNA CANADA LTD.
8724 HOLGATE CRESCENT
MILTON, ONTARIO L9T5Z1

Location of tensile fracture: inside middle of gage length.
Chemical Analysis performed at Acciaierie Valbruna, Italy.
No mercury or low melting alloy contamination. No weld repair.
Material melted in Italy, manufactured in the United States.
Material conforms to listed specifications and is DFARS compliant.
Quality system is compliant with ISO 9001:2008. Produced in accordance with EN 10204 3.1.

DAS
14
9-89*15/04/08*

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Manager Laboratory Services



email: DHackett@valbruna.us

Dennis Hackett

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6104-007
 DATE: 15/04/08

PO / BATCH NO.: 27890/130696

MATERIAL CERT REC'D: yes
 QUANTITY RECEIVED: 10
 QUANTITY INSPECTED: 10
 QUANTITY REJECTED: 0

THICKNESS ORDERED: 84.50 X 5.10
 THICKNESS RECEIVED: 84.50 X 5.10
 SHEET SIZE ORDERED: _____
 SHEET SIZE RECEIVED: _____

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	(N)	
CORRECT FINISH	(Y)	N	
CORROSION	Y	(N)	
CORRECT GRAIN DIRECTION	(Y)	N	
CORRECT MATERIAL	(Y)	N	
CORRECT THICKNESS	(Y)	N	
PHOTO REQUIRED	Y	(N)	
CORRECT MATERIAL	(Y)	N	
CORRECT REF # TO LINK CERT	(Y)	N	
CORRECT MATERIAL IDENTIFICATION	(Y)	N	
CORRECT M# ON THE MATERIAL	(Y)	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	(N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	(N)	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL SIZE OF TEST SAMPLE HARDNESS / DUROMETER READING	HRC	HRB	DUR A	DUR D	

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>DAS 14 9-89</u> DATE: <u>15/04/08</u>	SIGNED OFF BY: _____ DATE: _____		

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

MATERIAL RECEIPT INSPECTION FORM

INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
 - a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORRECT TO THE DART PO INSTRUCTIONS
- 6- REMOVE / CUT A PIECE OF MATERIAL FOR SAMPLE HARDNESS TESTING

INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN **20pcs** FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIREMENTS

INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIREMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
 - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
 - b. OUTSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
 - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTIFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC COORDINATOR BEFORE GOING FURTHER